

WE CLAIM:

1. A method for adjusting a spacing (20) within a magnetic circuit, in particular the spacing (20) between a magnet armature (1) and a magnet core (10), in which the magnet armature (1) has an armature plate (2) and an armature bolt (7) which are joined together in a relative position (21), the method comprising adjusting the relative position (21) between the armature plate (2) and the armature bolt (7) by a pressing operation, to a first defined size (24) or a second defined size (27), after the armature plate (2) and the armature bolt (7) are assembled to form the magnet armature (1).
2. The method of claim 1, further comprising monitoring the first defined size (24), characterizing the relative position (21) by means of a travel measuring system during the pressing operation.
3. The method of claim 1, wherein the pressing operation for adjusting the relative position (21) is effected in a pressing tool, by means of calibrated spacers that can be placed in the tool.
4. The method of claim 1, wherein the pressing operation for adjusting the relative position (21) is effected in a pressing tool, by means of calibrated shims that can be placed in the tool.
5. The method of claims 3, wherein after the pressing operation of the assembled magnet armature (1), the calibrated spacers or the calibrated shims are removed from the magnet armature.

6. The method of claims 4, wherein after the pressing operation of the assembled magnet armature (1), the calibrated spacers or the calibrated shims are removed from the magnet armature.
7. The method of claim 1, further comprising resting the armature plate (2) on one face end (33) of a receiving device (32) during the pressing operation of the preassembled magnet armature assembly (1), and acting upon the armature bolt (7) on one of its face ends (8, 9) with a pressing force (31) (F).
8. The method of claim 1, wherein in the pressing operation of the preassembled magnet armature assembly (1), the armature bolt (7) is fixed, and the armature plate (2) is acted upon with a pressing force (31) (F).
9. The method of claim 7, wherein during the pressing operation on the preassembled magnet armature assembly (1), the armature bolt (7) is thrust at a constant speed through an armature plate bore (5) of the armature plate (2).
10. The method of claim 1, wherein during the pressing operation of the magnet armature (1), a press fit (6) of the armature plate (2) on the jacket face of the armature bolt (7) is varied in terms of the relative position (21) of the armature plate (2) on the circumferential face of the armature bolt (7).
11. The method of claim 1, wherein during the pressing operation, the second defined size (27), characterizing the relative position (21) between the armature bolt (7) and the armature plate (2), is monitored continuously by means of a measuring feeler (35).
12. The method of claim 11, wherein the pressing force (31) (F) is initiated at the first face end (8) of the armature bolt (7) for adjusting the second defined size (27).

13. The method of claim 1, wherein the pressing force (31) (F) is applied to the preassembled magnet armature assembly (1) until such time as either the first defined size (24) or the second defined size (27) is reached, and wherein the pressing operation is ended via the measuring feeler (35) and a travel measuring system (38) disposed downstream of it.